

**Date:** September 2024  
**Rev:** XII  
**No. of Components:** Two  
**Mix Ratio by Weight:** 10 : 1  
**Specific Gravity:** Part A: 1.20      Part B: 1.09  
**Pot Life:** 24 Hours  
**Shelf Life- Bulk:** One year at room temperature  
**Shelf Life- Syringe:** One year at -40°C

**Recommended Cure: 150°C / 1 Hour**

Minimum Alternative Cure(s):  
*May not achieve performance properties listed below*  
 90°C / 30 Minutes

**NOTES:**

- Container(s) should be kept closed when not in use.
- Filled systems should be stirred thoroughly before mixing and prior to use.
- Performance properties (rheology, conductivity, others) of the product may vary from those stated on the data sheet when bi-pak/syringe packaging or post-processing of any kind is performed. Epoxy's warranties shall not apply to any products that have been reprocessed or repackaged from Epoxy's delivered status/container into any other containers of any kind, including but not limited to syringes, bi-paks, cartridges, pouches, tubes, capsules, films or other packages.
- If product crystallizes in storage, place container in warm oven until crystallization disappears. Please refer to Tech Tip #7 on website.

**Product Description:** EPO-TEK® 323LP is a two component, high temperature epoxy designed for semiconductor, hybrid, fiber, and optical applications. It is a longer pot life alternative of EPO-TEK® 353ND.

**Typical Properties:** Cure condition: 150°C / 1 Hour    Different batches, conditions & applications yield differing results.  
 Data below is not guaranteed. To be used as a guide only, not as a specification. \* denotes test on lot acceptance basis

PHYSICAL PROPERTIES:			
* Color (before cure):	Part A: Clear to slight yellow	Part B: Yellow	
* Consistency:	Pourable liquid		
* Viscosity (23°C) @ 50 rpm:	3,500 - 5,000	cPs	
Thixotropic Index:	N/A		
* Glass Transition Temp:	≥ 100	°C	(Dynamic Cure: 20-200°C/ISO 25 Min; Ramp -10-200°C @20°C/Min)
Coefficient of Thermal Expansion (CTE):			
	Below Tg:	51	x 10 <sup>-6</sup> in/in°C
	Above Tg:	185	x 10 <sup>-6</sup> in/in°C
Shore D Hardness:	88		
Lap Shear @ 23°C:	> 2,000	psi	
Die Shear @ 23°C:	≥ 20	Kg	7,112 psi
Degradation Temp:	413	°C	
Weight Loss:			
	@ 200°C:	0.31	%
	@ 250°C:	0.46	%
	@ 300°C:	0.85	%
Suggested Operating Temperature:	< 300	°C	(Intermittent)
Storage Modulus:	444,110	psi	
Particle Size:	N/A		

ELECTRICAL AND THERMAL PROPERTIES:			
Thermal Conductivity:	N/A		
Volume Resistivity @ 23°C:	≥ 3 x 10 <sup>12</sup>	Ohm-cm	
Dielectric Constant (1KHz):	2.62		
Dissipation Factor (1KHz):	0.003		

OPTICAL PROPERTIES @ 23°C:			
Spectral Transmission:	≥ 94% @ 820-1,620	nm	
	≥ 90% @ 640-800	nm	
Refractive Index:	1.5704 @ 589	nm	

**Epoxy and Adhesives for Demanding Applications™**

**This information is based on data and tests believed to be accurate. Epoxy Technology, Inc. makes no warranties (expressed or implied) as to its accuracy and assumes no liability in connection with any use of this product.**

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**EPO-TEK® 323LP Advantages & Suggested Application Notes:**

- 24 hour pot life to promote mass production usage. It has an amber color change upon cure.
- Semiconductor:
  - Wafer to wafer bonding of CSP; fabrication of MEMs devices; flip chip underfill.
- Hybrid:
  - Providing near hermetic seals and UHV seals in sensor devices, resisting high temperature packaging.
  - Down-Hole petrochemical fiber optic sensors, resisting >200°C field conditions.
- Fiber optic adhesive designed to meet Telecordia 1221:
  - Sealing fiber into ferrules, transmitting light in the optical pathway from 800-1,550 nm range.
  - Fiber component packaging; adhesive for active alignment of optics, environmental seal of opto-package, V-groove arrays.
- Electronic Assembly:
  - Used as dielectric layer in the fabrication of capacitors; laminating PZT piezoelectrics.
  - Impregnating and insulating copper coil windings in motors and inductor coils. Bonding ferrite cores and magnets.

**Epoxy Technology** Epoxies and Adhesives for Demanding Applications™

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